

Work Order ID 68393

Tuesday, April 12, 2011 3:34:59 PM



PRELIMINARY ISSUE

Page 1

Item ID:	D4364-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Fwd Wearplate Assembly					
Start Date:	4/12/2011	Start Qty:	1.00			
Required Date:	4/15/2011	Req'd Qty:	1.00			
Reference:						

Cust Item ID:
Customer:



Approvals:	Process Plan:		Date:	11-04-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4364	PA1								

100		0.00							
	Waterjet								
FLOW CNC Waterjet									
304 . 000									
	Memo	0.00							
	1-Cut as per Dwg (D4364-1)								
	Dwg Rev: <u>PA1</u>								
	Prog Rev: <u>PA1</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC									
Quality Control	Memo	0.00							

B11-4-19

①

B11-4-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4364-041

Accept



Setup Start



Revision ID: PRELIM

Item Name: Fwd Wearplate Assembly

Stop



Start Date: 4/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspected to PA1



QC

Memo

0.00

Quality Control

Dug only
8/11/04/20 (R)

130

Form as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

SB 11/04/20

140

QC5- Inspect part completeness to step on W/O

0.00 - inspected to PA1



QC

Memo

0.00

Quality Control

Dug only
8/11/04/20

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Page 3

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Revision ID: PRELIM

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Start Date: 4/12/2011 Start Qty: 1.00

Required Date: 4/15/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

Large Fab

Large Fab

Memo

0.00

1- on D4365-1, fill cut outs with hardcoat welding rod as per dwg D4364 **USE
DT9756**

2059 B Hardcoat Welding Rod

BATCH#: ~~1117659~~ 1117659

2-weld D4365-1 to wearplate by positioning holes together as per dwg D4364

304 S.S. Welding Rod

BATCH #: 11107051

3-Transfer drill holes in bar

160

0.00

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

W/O:		WORK ORDER CHANGES					
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Tuesday, April 12, 2011 3:34:59 PM

Page 4

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Item Name: Fwd Wearplate Assembly
Start Date: 4/12/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/15/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>inspects to PA1</i> <i>Denote</i> <i>Subtotal</i>						
180  Small Fab Small Fab	Memo 1- After finish, coat entire top (concave) surface as per note 10 on sheet 2 dwg D4364. <i>Black Rockerguard Plus 1 m116210</i>	0.00 0.00	<i>11 02 09 (1)</i>						
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Page 5

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Item Name: Fwd Wearplate Assembly
Start Date: 4/12/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/15/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				_____	_____	_____	_____
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				_____	_____	_____	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 3:35:05 PM

Page 1

Work Order ID: 68393

Parent Item: D4364-041

Parent Item Name: Fwd Wearplate Assembly



Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA  304/316 .050 Sheet		Purchased	No			100	sf	204.0000	2.6827	2.823895			
 B11-4-19													

Location

Loc Qty

Loc Code

MAT020

204

111743

1

112178

4

113062

18

116135

48

116604

37

116979

96

116035

①

D4365-1

Manufactured

No

150

Each

0.0000

1

1



Bar



EL 11-6-8

68393

already pulled on RP2382.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD

Description: FWD WEAR PLATE ASSEMBLY

Inspection Dwg: D4364-1 , Rev: PA1

Work Order: 68393
68893

Part Number: D4364-041

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1400	$\pm .010$	1404	x		V HB 02	
.875	$\pm .010$.875	x		V	
.125	$\pm .010$.129	x		V	
3.00	$\pm .03$	3.000	x		V	
φ .188	$+ .005 - .001$.193	?		V	
5.320	$\pm .010$	5.317	?		V	
.56	$\pm .030$.557	x		V	
.80	$\pm .030$.80	x		V	
4.20	$\pm .030$	4.203	x		V	
7.06	$\pm .030$	7.063	x		V	
4.06	$\pm .030$	3.997	x		V	
23.500	$\pm .010$	23.500	x		T HB 01	
15.450	$\pm .010$	15.456	?		T	
30.175	$\pm .010$	30.175	?		T	
42.175	$\pm .010$	42.175	?		T	
43.35	$\pm .030$	43.35	?		T	
.050	$\pm .010$.048	x		V	

Measured by: RB

Date: 11-4-19

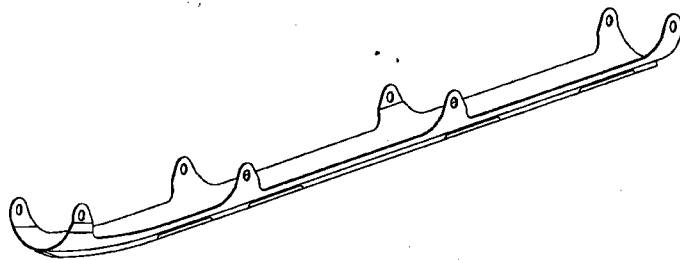
Audited by: S

Date: 11/04/20

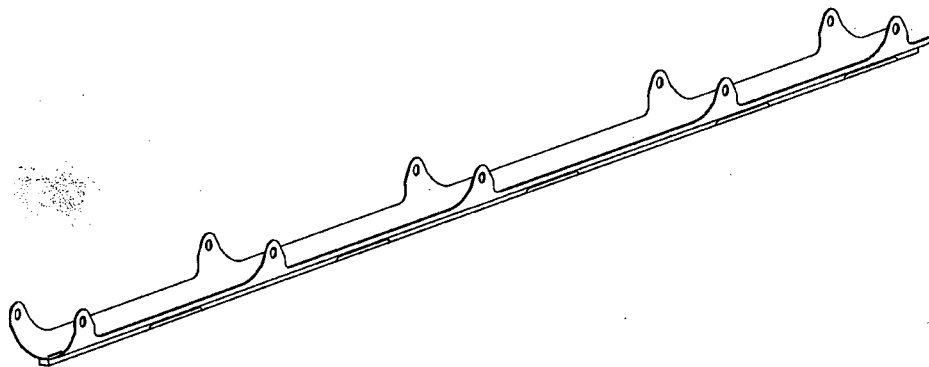
Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4364-041 FWD WEARPLATE ASSY



D4364-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X		D4364-041	FWD WEARPLATE ASSY
		X	D4364-043	AFT WEARPLATE ASSY
1	1		D4364-1	PLATE
2		1	D4364-3	PLATE
3	1		D4365-1	BAR
4		1	D4365-3	BAR
5	A/R	A/R	2059B	HARDCOAT
6	A/R	A/R	ROCKGUARD 4714	SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68393

11-01-12

**PRELIMINARY
ISSUE**

PA1	NEW ISSUE	SC	11.03.24
REV.		DESCRIPTION	BY DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4364	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

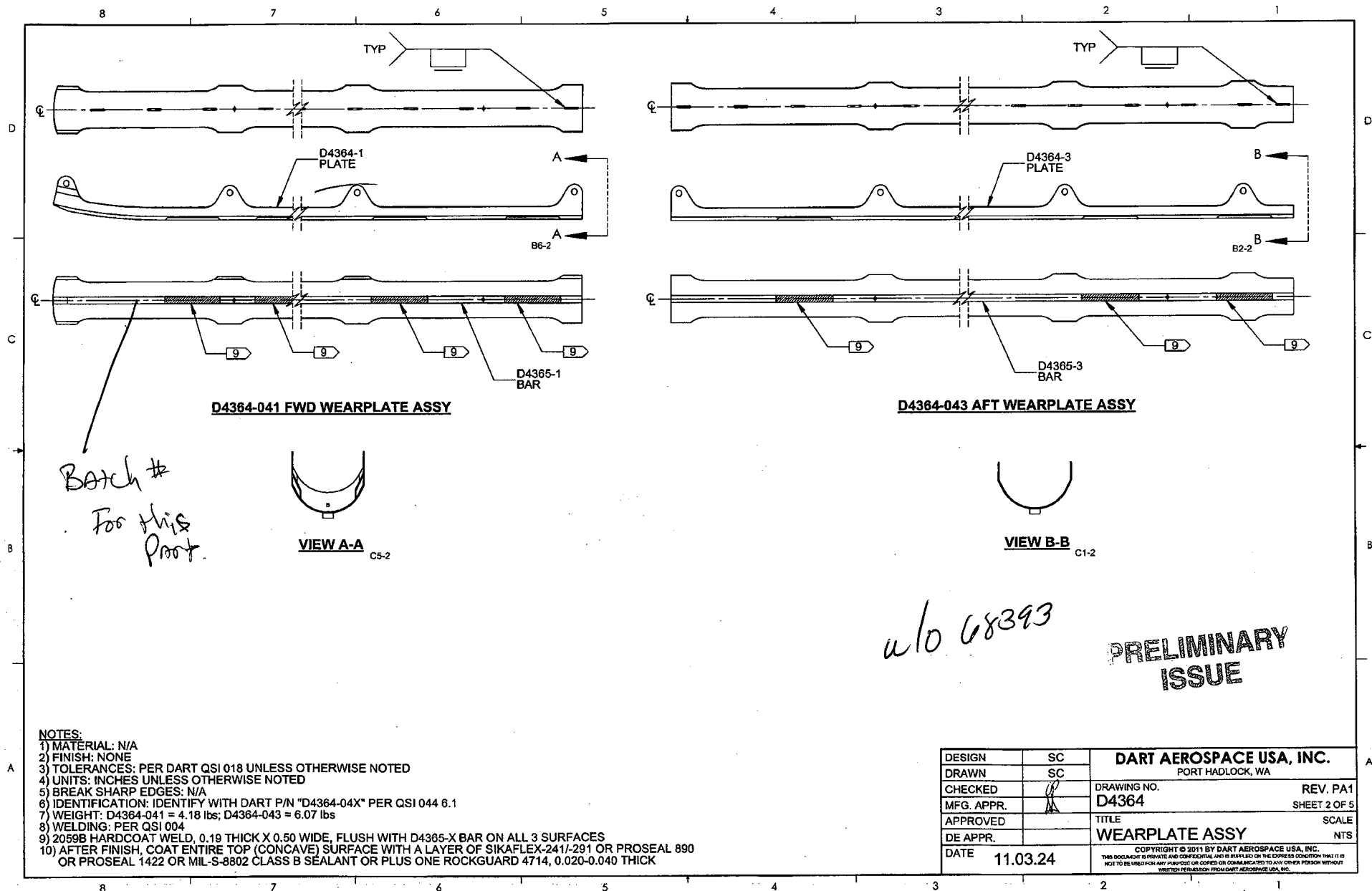
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



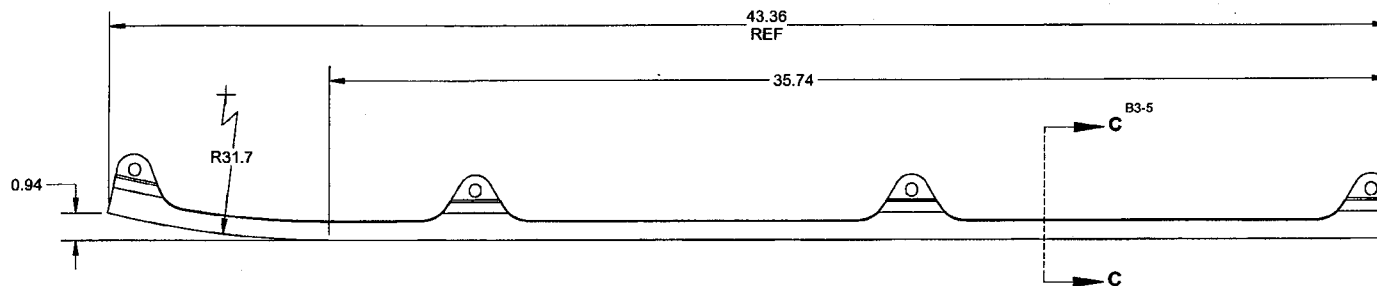
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

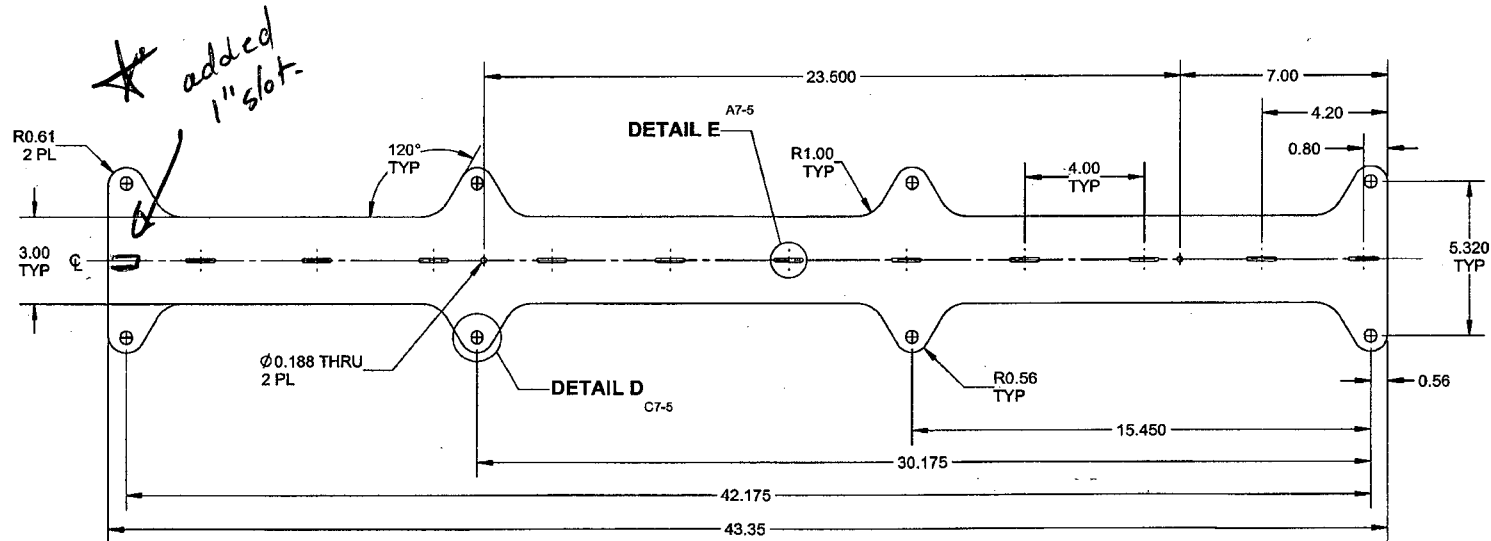
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4364-1 PLATE
(MAKE FROM D4364-1F)



D4364-1F PLATE

**PRELIMINARY
ISSUE**

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.12 lbs

Wb 68393

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	SC	DRAWING NO. D4364	REV. PA1
MFG. APPR.	SC	SHEET 3 OF 5	
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEARPLATE ASSY	NTS
DATE	11.03.24	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUBJECT TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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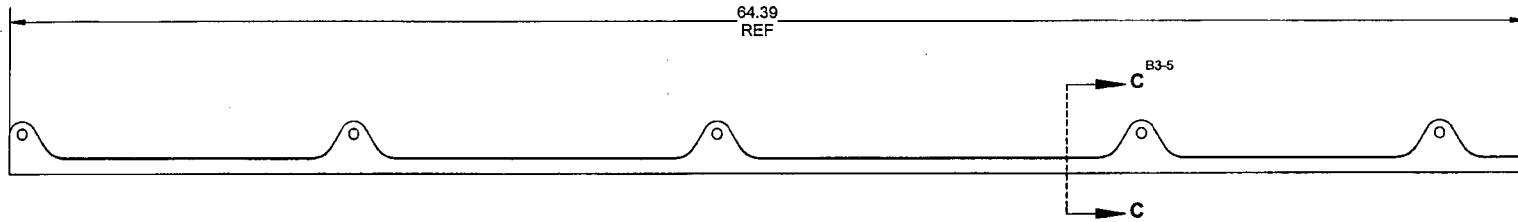
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

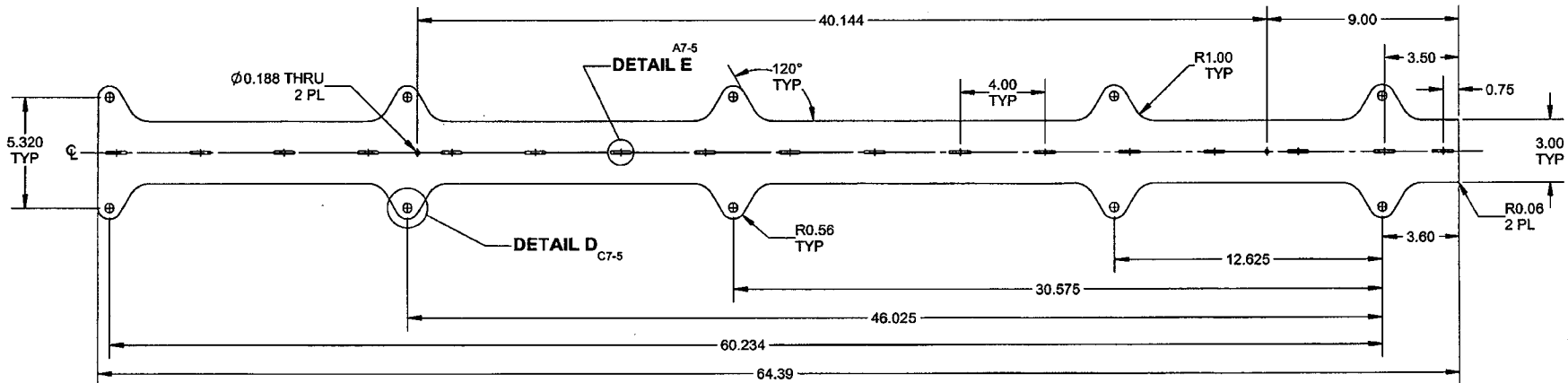
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4364-3 PLATE
(MAKE FROM D4364-3F)



D4364-3F PLATE

u/o 48393

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.10 lbs

**PRELIMINARY
ISSUE**

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8 7 6 5 4 3 2 1

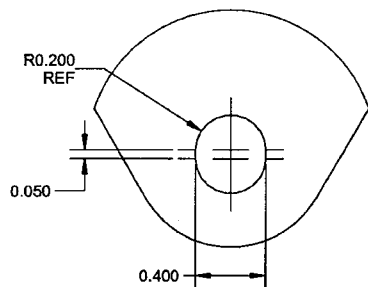
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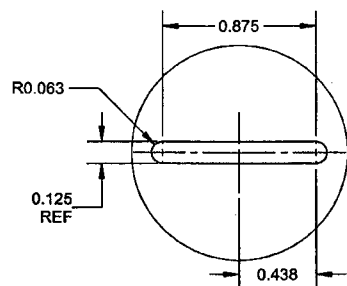
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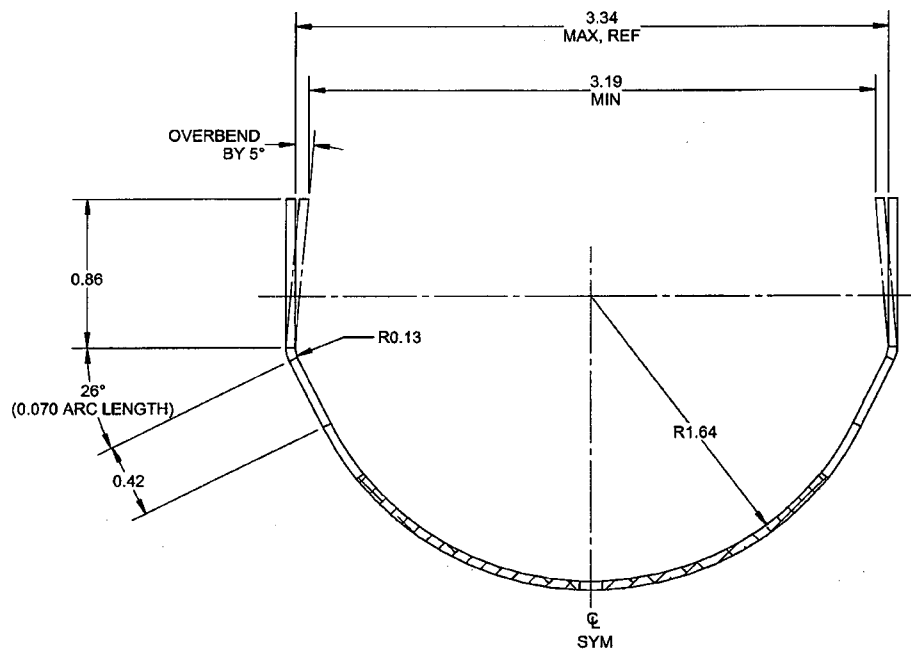
DETAIL D
SLOT DETAIL TYP

B5-3
B5-4



DETAIL E
SLOT DETAIL TYP

C5-3
C5-4



SECTION C-C

D3-3
D3-4

**PRELIMINARY
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a/o 68393

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